

# Work Order ID 73228

Friday, August 26, 2011 10:27:32 AM



Page 1

Item ID: D3315-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/08/26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3315	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3315 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

1010-062

B11-8-30

(5)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-8-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subs/30

(45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73228

Friday, August 26, 2011 10:27:32 AM



Page 2

Item ID: D3315-4

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Setup Start



Revision ID:

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Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Brake NC

NC BRAKE

Memo

0.00

Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

8/11/09/01

5

140

0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

8/11/09/01

5

Quality Control

150

0.00



Large Fab

Large Fab

Memo

0.00

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev:

☐ Qty Part Number Description Batch ☐ A/R

N/A 7560 Hardcoat Rod

m117964

X5 11-09-07 JBL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73228**

Friday, August 26, 2011 10:27:32 AM



Page 3

Item ID: D3315-4

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Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC10- Inspect visual per QSI004- ground welds

0.00

8/16/07



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

8/16/07



QC

Memo

0.00

Quality Control

②  
-4

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

Powder Coating

START TIME: 2:15 □OVEN TEMPERATURE:

□FINISH TIME:

3200F

2:45

5X Ø M-11/09/07

M117338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73228

Friday, August 26, 2011 10:27:32 AM



Page 4

Item ID: D3315-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 8/26/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

5 6 11/09/07

200

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐ TCCA-PDA, Dart Aerospace Ltd. ☐ P/N: D3315-4, B/N: BXXXXX ☐ For Product Eligibility see PDA04-17 ☐ and Stock ☐ Location: ST 496

SP

SP 11-09-08

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/07

mf 11-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, August 26, 2011 10:27:29 AM

Page 1

Work Order ID: 73228

Parent Item: D3315-4

Parent Item Name: Wearplate



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A 05.05.12 New issue KJ/JLM  
IPP Rev:B As per Rev B 06-03-24 JLM  
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

134.3000

2.296

12.08421



B11-8-30

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

134.3

116791

32.5

117500

101.8

17500



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

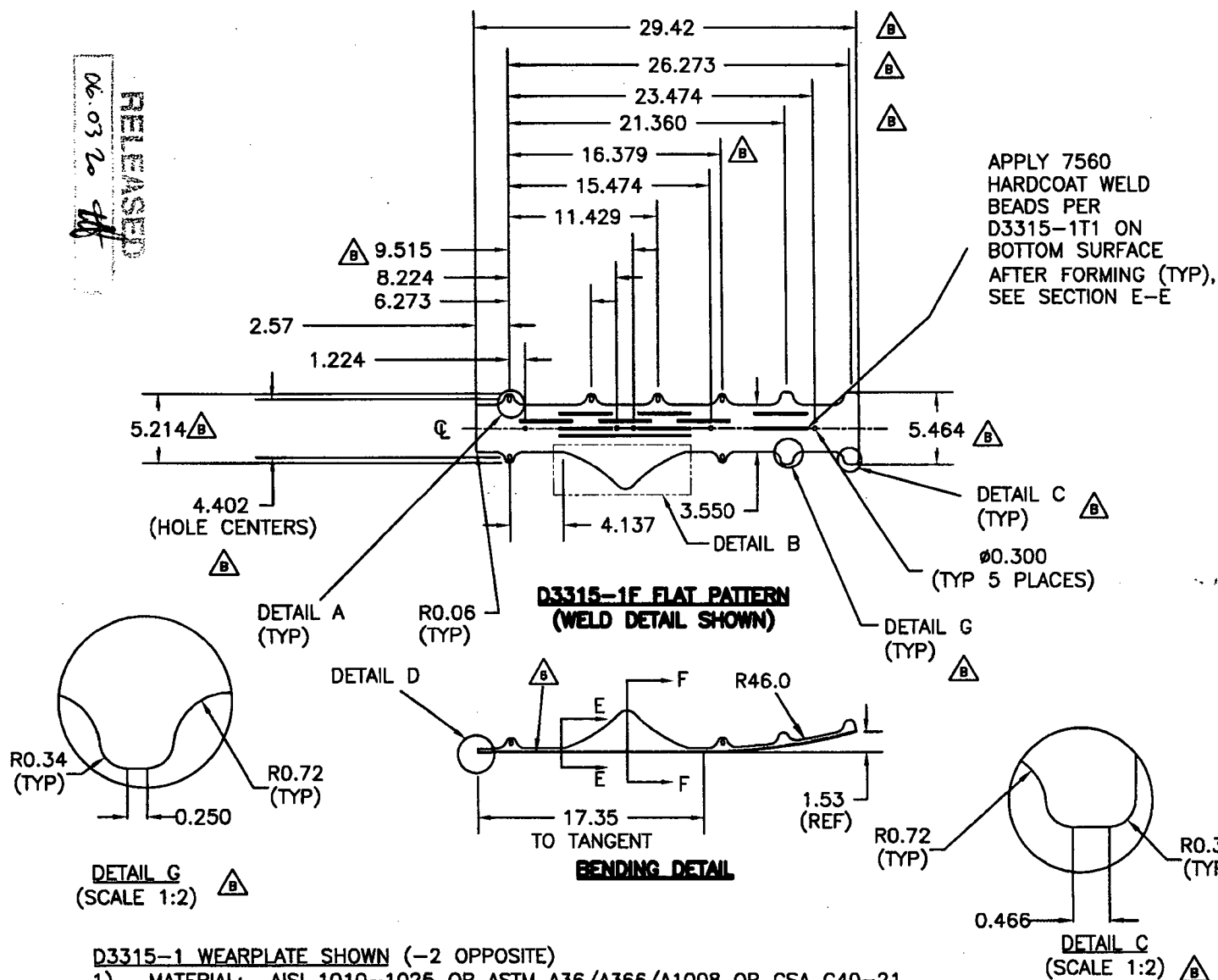
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DESIGN	814	DRAWN BY	814	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED			REV. B
DATE	06.01.31	TITLE	WEARPLATE		SHEET 1 OF 4
A	04.09.10	SCALE	1:12		
B	06.01.31	UPDATE DIMENSIONS			



3. SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 73228

D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- \*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

CL 1108/24

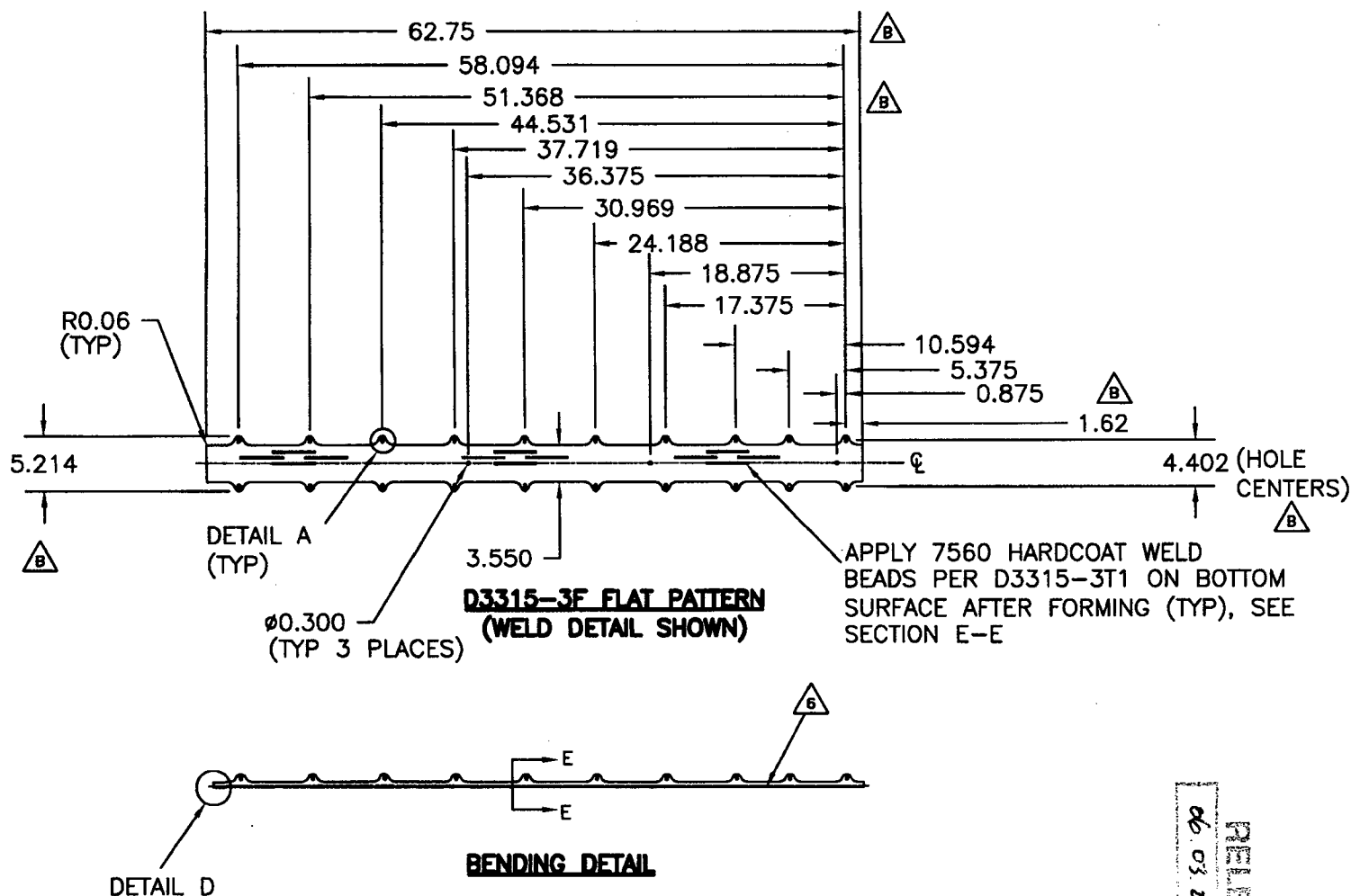
DELEST

06.03.20

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**DART**



**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

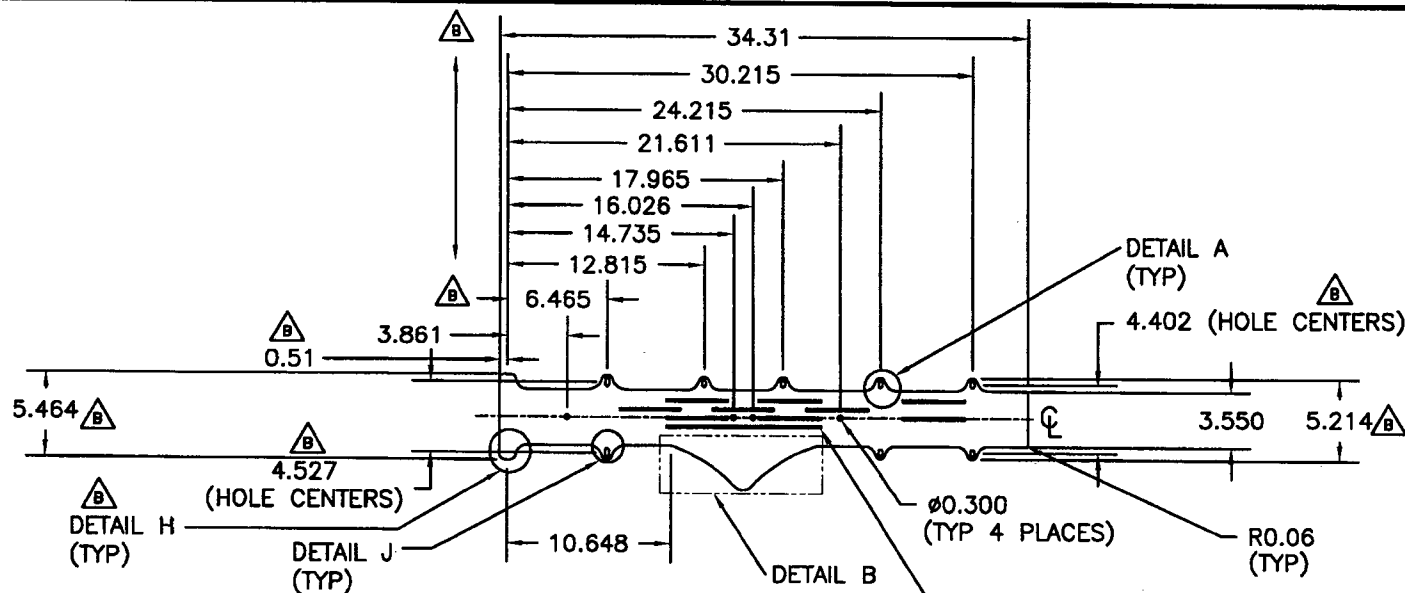
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED  
26 03 20

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
DATE	06.01.31			D3315	SHEET 2 OF 4
				TITLE	SCALE
				WEARPLATE	1:16

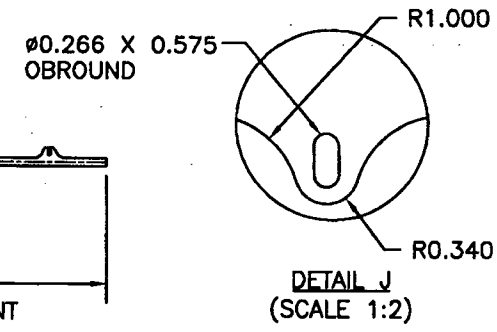
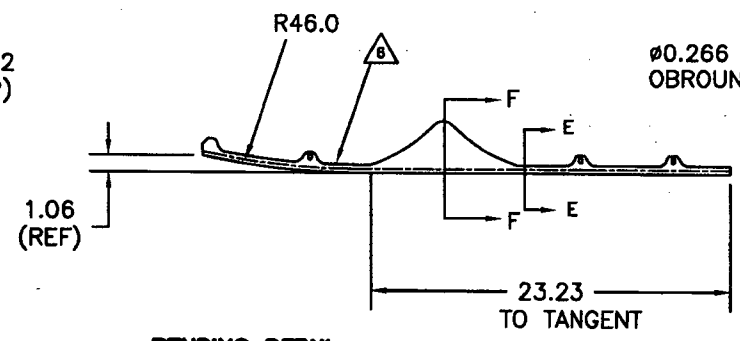
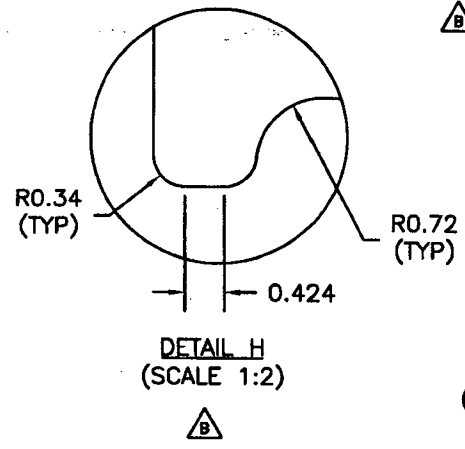
**DART**

06 03 10  
RELEASED



**D3315-5F FLAT PATTERN  
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD  
BEADS PER D3315-5T1 ON BOTTOM SURFACE  
AFTER FORMING (TYP), SEE SECTION E-E



**D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
  - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
  - 3) WELD PER DART QSI 004
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSION ARE IN INCHES
  - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 3 OF 4
				SCALE 1:12

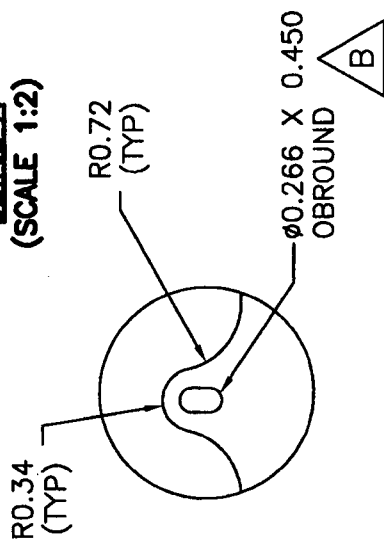
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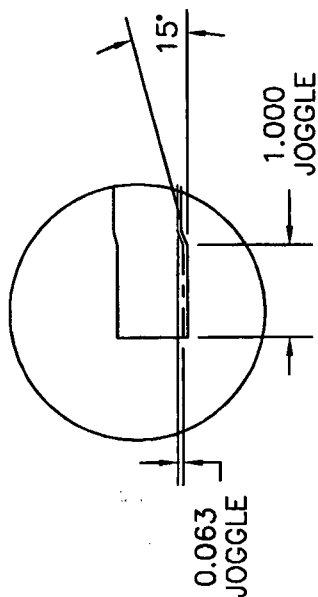


DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31		TITLE WEARPLATE	SCALE NTS

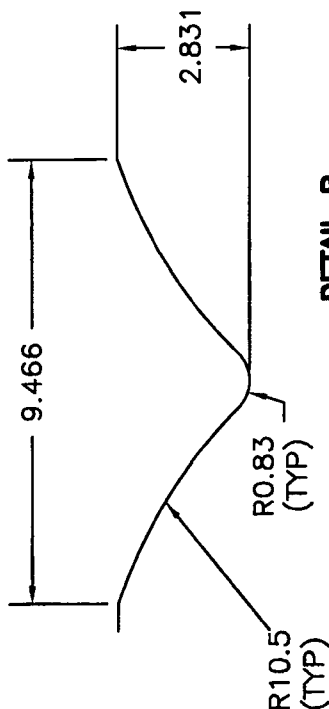
**DETAIL A**  
(SCALE 1:2)



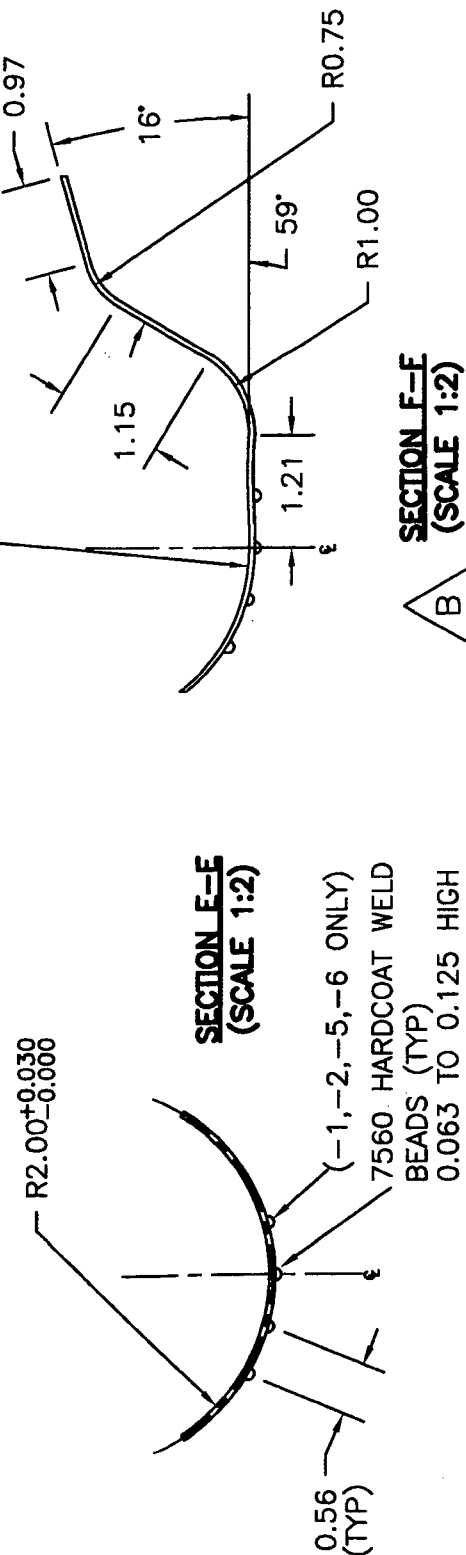
**DETAIL D**  
(SCALE 1:2)



**DETAIL B**  
(SCALE 1:4)



**SECTION E-E**  
(SCALE 1:2)



**SECTION F-F**  
(SCALE 1:2)

(-1,-2,-5,-6 ONLY)  
7560 HARDCOAT WELD  
BEADS (TYP)  
0.063 TO 0.125 HIGH

RELEASED  
06.03.20 *[Signature]*

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DART AEROSPACE LTD		Work Order: 73227
Description: WEARPLATE		Part Number: D 3315-9
Inspection Dwg: D 3315-3, Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .300	+ .006 - .001	.301	2		V	Bo 2
266X453	± .010	266X453	X		V	
5.214	± .010	5.213	>		V	
4.402	± .010	4.395	>		V	
1.62	± .030	1.627	0		J	
.875	± .010	.875	0		V	
3.550	± .010	3.555	>		V	
5.375	± .010	5.375	X		T	Bo 1
10.594	± .010	10.594	0		T	
17.375	± .010	17.375	0		T	
18.875	± .010	18.875	0		T	
24.188	± .010	24.188	0		T	
30.969	± .010	30.969	0		T	
36.375	± .010	36.375	0		T	
37.719	± .010	37.719	0		T	
44.531	± .010	44.531	>		T	
51.368	± .010	51.368	0		T	
58.694	± .010	58.694	2		T	
62.75	± .030	62.75	X			
.060	± .010	.061	2		V	

Measured by: RB	Audited by: J	Prototype Approval:
Date: 11-8-30	Date: 11/08/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

